

Cored Wires Stainless and Heat resistant steels

Fluxinox 309MoL is an alloyed rutile flux cored wire mainly used for cladding. The highest operating temperature for dissimilar joints is 300 °C.

Fluxinox 309MoL exhibits outstanding, almost spatter-free, welding properties. It produces finely rippled, flat and smooth welds, free of undercut with very easy slag removal. The weld metal, containing approximately 20% ferrite, is crack-resistant and therefore well-suited for buffer layers on high-carbon, difficult to weld steels.

Classification	
AWS	A5.22: E309LMoT0-4 / E309LMoT0-1
EN	12073: T 23 12 2 L R M 3 / T 23 12 2 L R C 3

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.04	1.50	0.70	-	-	24	13	2.50	-	-	-	12-20

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) + 20 °C	Hardness
As Welded	≥ 350	≥ 550	≥ 25	≥ 40	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

Materials

Cladding of carbon steel and low alloy steel

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



PA PB PC

Packaging data: K300 kg. 16

Diameters	1,2					
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